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RB KIT 407M
Job Sheet 200029



Part No: RB KIT 407M

Job Qty: 1 pcs *32*

Part Name: Spline Measuring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 10/28/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	1 pcs	10/28/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		<i>GP 19-10-18</i>
							Small Fab - 7		
							Small Fab - 8		
100	Small Fab - 2 - B4B	1 pcs	10/28/19		0.00	1.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		<i>GP 19-10-18</i>
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
110	QC 5	1 pcs	10/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		

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				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		OCT 18 2019
				QC 5 - 61		
				QC 5 - 81		
130 Packaging 3-1 - Stock - B4B 1 pcs	10/28/19	0.00 0.00		Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B	PC	GA092F
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
140 QC 21 - FG	1 pcs	10/28/19	0.00 0.00	QC 21 - FG - 21		OCT 21 2019
				QC 21 - FG - 70		
				QC 21 - SA - 53		

Part Op 90 - Print sheet 3 of 5 of the dwg. for labels and cut out. -Ensure that pins are placed in a 2" X 2" plastic bags with a small amount of LPS 2. Place pins and bags in vials with the correct label. -Assemble kit.

100 - -Print sheet 3 of 5 of the dwg. for labels and cut out. -Ensure that pins are placed in a 2" X 2" plastic bags with a small amount of LPS 2. Place pins and bags in vials with the correct label. -Assemble kit.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____ - Identify and Stock

140 - QC21- Final Inspection - Work Order Release

012499

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1120-E	Case 128 AB	1 Ea (1 ea)	90-Small Fab - 1	189191
071600	Vials w/Lids 218	16 Ea (16 ea)	100-Small Fab - 2 - B4B	?
97524A031	Rivet 40	4 Ea (4 ea)	100-Small Fab - 2 - B4B	*
RB KIT 407M-01 Gauge Pin .0240" dia.	90	2 pcs (2 ea)	100-Small Fab - 2 - B4B	5151062
RB KIT 407M-03 Gauge Pin .0400" dia.	90	2 pcs (2 ea)	100-Small Fab - 2 - B4B	5219565 x 2 384 x 4
RB KIT 407M-05 Gauge Pin .0540" dia.	90	2 pcs (2 ea)	100-Small Fab - 2 - B4B	219551
RB KIT 407M-07 Gauge Pin .0600" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	219594
RB KIT 407M-09 Gauge Pin .0800" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	151981 x 2 218718 x 4
RB KIT 407M-11 Gauge Pin .0960" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	218750
RB KIT 407M-13 Gauge Pin .1080" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	218769
RB KIT 407M-15 Gauge Pin .1200" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	218793
RB KIT 407M-17 Gauge Pin .1440" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	218779
RB KIT 407M-19 Gauge Pin .1440" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	156817
RB KIT 407M-21 Gauge Pin .1600" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	152023 x 2 494 x 4
RB KIT 407M-23 Gauge Pin .1600" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	103081 x 3 6363
RB KIT 407M-25 Gauge Pin .1728" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	219438
RB KIT 407M-27 Gauge Pin .1728" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	219386
RB KIT 407M-29 Gauge Pin .1800" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	121647 x 2 846 x 4
RB KIT 407M-31 Gauge Pin .1920" dia.	"	2 pcs (2 ea)	100-Small Fab - 2 - B4B	219444
RB KIT 407M-35 Labels	N/A	1 pcs (1 ea)	100-Small Fab - 2 - B4B	N/R
RB KIT 407M-39 Bottom Foam (Ethafom 220, Black, 2.58 x 4.83 x 7.34) use with case APP-1120-E		1 Ea (1 ea)	100-Small Fab - 2 - B4B	5189188
RB KIT 407M-41 Top Foam (Ethafom 220, Black, 0.45 x 4.79 x 7.26) use with case APP-1120-E		1 Ea (1 ea)	100-Small Fab - 2 - B4B	5189189
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	APP-1120-E	1	21	0
	071600	16	4,600	0
100-Small Fab - 2 - B4B	97524A031	4	80	0
	RB KIT 407M-01	2	8	0
	RB KIT 407M-03	2	8	0
	RB KIT 407M-05	2	8	0
	RB KIT 407M-07	2	1	0
	RB KIT 407M-09	2	8	0
	RB KIT 407M-11	2	1	0
	RB KIT 407M-13	2	4	0
	RB KIT 407M-15	2	3	0
	RB KIT 407M-17	2	10	0
	RB KIT 407M-19	2	15	0
	RB KIT 407M-21	2	2	0
	RB KIT 407M-23	2	31	0
	RB KIT 407M-25	2	4	0
	RB KIT 407M-27	2	6	0
	RB KIT 407M-29	2	10	0
	RB KIT 407M-31	2	1	0
	RB KIT 407M-35	1	0	0
	RB KIT 407M-39	1	17	0
	RB KIT 407M-41	1	17	0
	RB41011	1	249	0

Part Specifications

Specifications could not be found.

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TABLE 1
GAUGE PIN DIMENSIONS

PART NUMBER	ØA	B	PURCHASE PART NUMBER (MASTER CARR)
RB KIT 407M-01	Ø.02400	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	Ø.04000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-06	Ø.05400	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	Ø.08000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	Ø.08000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	Ø.08600	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	Ø.10300	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	Ø.12000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	Ø.14400	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	Ø.14400	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	Ø.16300	0.25"	21135A54 OR EQUIV.
RB KIT 407M-23	Ø.16000	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	Ø.17280	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	Ø.17280	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	Ø.18000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	Ø.18200	1.00"	21135A55 OR EQUIV.

RRB KIT 407M-01 THRU -31 Ø.XXXX, CLASS X PLUG NO-GO GAUGE

NOTES:
1) MATERIAL : SEE TABLE 1 FOR MATERIAL SPECIFICATION

2} HEAT TREAT: N/A

3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$

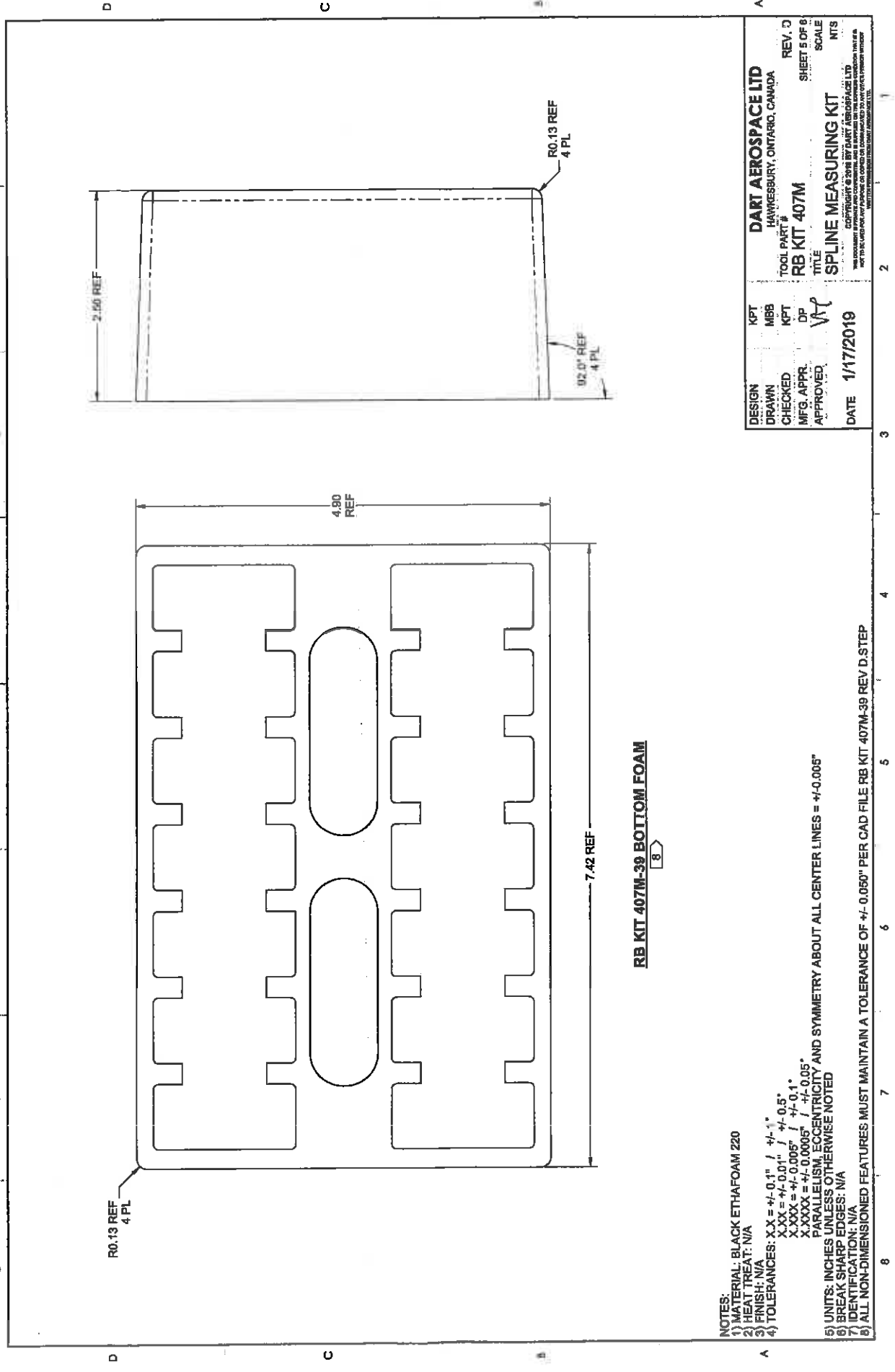
X.XXX = ± 0.001 " / ± 0.001 "
X.XXX = ± 0.005 " / ± 0.1 "
X.XXXX = ± 0.0005 " / ± 0.05 "
PARALLELISM, ECCENTRICITY AND
INCHES UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE SPECIFIED

7) IDENTIFICATION: N/A

[illegible]

2 3 4 5 6 7 8



RB KIT 407M-39 BOTTOM FOAM

NOTES:
1) MATERIAL: BLACK ETHAFOAM 220
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB KIT 407M-39 REV D STEP

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	DP	RB KIT 407M
APPROVED	VP	TITLE
DATE	1/17/2019	SPLINE MEASURING KIT
		REV. 3
		SHEET 5 OF 8
		SCALE
		NTS

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